



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7814
Job Sheet 181400



Part No: 647.7814

Job Qty: 50 ea

Part Name: Fwd Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV A RQ 13/12/23 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		9/10/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	50 pcs		9/10/18	0.00	0.02	Bandsaw1		
110	CNC Vertical Machining	50 pcs		9/10/18	0.04	24.88	HAAS1-1		
120	QC	50 pcs		9/10/18	0.00	0.00	QC2 Machining-1		
130	QC	50 pcs		9/10/18	0.00	0.00	QC8 Machining-1		
140	Outsource	50 pcs		9/10/18			ATG001-VC	5	
150	Packaging	50 pcs		9/10/18	0.00	0.00	Packaging2		
160	QC	50 pcs		9/10/18	0.00	0.00	QC5		
180	Packaging	50 pcs		9/10/18	0.00	0.00	Packaging3-1		
190	QC21-SA	50 Ea		9/10/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks at 4.625"

Descriptions: 110 - 1-Machine per folio FB241

140 - Issue P/O to ATG : *P00411165* Hard Black Anodize and Prime as per Dwg. 647.7800 Rev. A

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B1.500X1.500	7075 T6 Bar 1.500 X 1.500	19.2500 ft (.385 ea)	90-Start up Operation	<i>FMB385L3</i> <i>3070 S102373</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6B1.500X1.500	19	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Bracket	0.800Degrees ± 0.500	1.300 0.300	Angle	<i>0,900°</i>
2	Fwd Bracket	151.500Degrees ± 0.500	152.000 151.000	Angle	<i>151,5°</i>
3	Fwd Bracket	41.900Degrees ± 0.500	42.400 41.400	Angle	
4	Fwd Bracket	71.700Degrees ± 0.500	72.200	Angle	

DQA: _____ Date: _____

WORK ORDER NO. _____ CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework Scrap Use-as-is Suspected Unapproved
Part No. _____	
NCR No. _____	

Date : _____ Step #: _____

Description Work Order Deviation

Date: 09/23/18

DART
AEROSPACE

1270 Aberdeen Street
Hamlet, NY 11946
TEL: 631 692-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part: 647.7814
Job No: 181400
Serial No/Batch: S112691

Container No: S112691

Revision:
Inspector:
Exp Date:
Instructions:

QC / QA Coordinator
Approval

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

			71.200	
5	Fwd Bracket	0.436Inches ± 0.002	0.438 0.434	, 436
6	Fwd Bracket	0.030Inches ± 0.005	0.035 0.025	, 033
7	Fwd Bracket	2.705Inches ± 0.002	2.707 2.703	2, 705
8	Fwd Bracket	3.955Inches ± 0.002	3.957 3.953	3, 955
9	Fwd Bracket	4.440Inches ± 0.005	4.445 4.435	4, 442
10	Fwd Bracket	0.448Inches ± 0.002	0.450 0.446	, 447
11	Fwd Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176	Diameter , 177
12	Fwd Bracket	0.140Inches ± 0.005	0.145 0.135	
13	Fwd Bracket	45.000Degrees ± 0.500	45.500 44.500	Angle
14	Fwd Bracket	0.170Inches ± 0.005	0.175 0.165	, 170
15	Fwd Bracket	0.170Inches ± 0.005	0.175 0.165	, 171
16	Fwd Bracket	0.683Inches ± 0.005	0.688 0.678	
17	Fwd Bracket	1.155Inches ± 0.005	1.160 1.150	
18	Fwd Bracket	0.125Inches ± 0.005	0.130 0.120	Radius , 125

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041165**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041165

PO Date: 9/27/18

Due Date: 10/25/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, Chrisoula Phone: -

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181400	647.7814	Fwd Bracket Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg. 647.7800 Rev. A	Firmed	-	10/25/18	50 pcs	0 pcs	50 pcs	\$7.85/pcs	\$392.50
				50 X		OCT 11 2018					DAS 68 9-89
2	181408	647.7817	Aft Bracket Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	-	10/25/18	50 pcs	0 pcs	50 pcs	\$7.85/pcs	\$392.50
				50 X		OCT 11 2018					
3	181415	647.1611	Wiper Deflector, Aft Issue P/O to ATG :	Firmed	-	10/25/18	48 pcs	0 pcs	48 pcs	\$11.70/pcs	\$561.60
Grand Total:											\$1,346.60



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PURCHASE ORDER PO041165

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/4/18 1:46 PM dart.beeecraft.ashley



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916202

Date: 10-Oct-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
50 ea	Part: 647.7814 Fwd Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23872	Rev: A PO: PO041165	Line: 1
50 ea	Part: 647.7817 Aft Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23873	Rev: A PO: PO041165	Line: 2
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>10/10/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

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